

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008293**Date Inspected:** 30-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Zhang Jin Xin		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No
<b>Weld Procedures Followed:</b>	Yes	No
<b>Verified Joint Fit-up:</b>	Yes	No
<b>Approved WPS:</b>	Yes	No
<b>Delayed / Cancelled:</b>	Yes	No
<b>Component:</b>	OBG	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2-

This QA Inspector observed the following work in progress: SAW welding Floor Beam weld FB03085-001-026. ZPMC welder was identified as 207237. ZPMC QC was identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 3-

This QA Inspector observed the following work in progress: FCAW welding of Floor Beam weld FB003-183-049, 050. ZPMC welder was identified as 044830. ZPMC QC was identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Bay 9-

This QA Inspector observed the following work in progress: FCAW welding of U rib Splice weld DP3067-001-022. ZPMC welder was identified as 201250. ZPMC QC was identified as Zhang Jin Xin. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

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## WELDING INSPECTION REPORT

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FCAW welding of U rib internal diaphragm plate welds DP3017-001-175, 176. ZPMC welders were identified as 059421 and 062265. ZPMC QC was identified as Zhang Jin Xin. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2133 and WPS-B-T-2233-TC-U4b-F.

Bay 10-

This QA Inspector observed the following work in progress: FCAW welding Skin A to Skin E corner joint weld SSTL3-1 B/K 82B on the South Tower Lift 3. ZPMC welder was identified as 050041. ZPMC QC was identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-C-U2-F.

Bay 11-

This QA Inspector observed the following work in progress: FCAW welding of longitudinal stiffener welds WSD1-FCSA4-2- B/C- 2, 3 and 5 on Skin Plate C of West Tower Lift 4. ZPMC welders were identified as 068864, 066683 and 06216. ZPMC QC was identified as Peng Guo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2332-TC-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation occurred between QA and QC this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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